

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015404**Date Inspected:** 28-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wuzhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD

This QA inspector measured and recorded offset between below segment for T-Rib (Web and Flange) along with ABF and ZPMC. The measurements are recorded in the designated sheet and forwarded to team leader for further action.

9AE-9BE (PP 73 – PP 74)

For further information, Please see the attached picture below:

OBG # TRIAL ASSEMBLY YARD

This QA inspector witnessed final tension verification for Traveler rail brackets of Lift 7E (7AE to 7EE).

Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP 48 to PP 60: M20 X 160 – DHGM 200007 – 360 NM

PP 48 to PP 60(Except PP 53): M22 X 120 – DHGM 220052 – 463 NM

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PP 53: M22 X 130 – DHGM 220055 – 513 NM

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (9BE-9CE)

SMAW Process:

Welding of weld joint – 007 located on PCMK OBE9B, Side panel transverse splice weld joins segment 9BE and 9CE. Welder is identified as 048659. ZPMC CWI is identified as Wuzhi Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

OBG # TRIAL ASSEMBLY YARD (9AW-9BW)

SMAW Process:

Welding of weld joint – 032 located on PCMK SP668-001, Side panel T Rib CJP weld joins segment 9AW and 9BW. Welder is identified as 067552. ZPMC CWI is identified as Wuzhi Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

SMAW Process:

Welding of weld joint – 043 located on PCMK SP490-001, Side panel T Rib CJP weld joins segment 9AW and 9BW. Welder is identified as 067552. ZPMC CWI is identified as Wuzhi Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversation.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
